

## Patent Abstracts of Japan

PUBLICATION NUMBER

60037201

**PUBLICATION DATE** 

26-02-85

APPLICATION DATE

08-08-83

APPLICATION NUMBER

58143682

APPLICANT: KAWASAKI STEEL CORP;

INVENTOR: INOUE MASATOSHI;

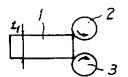
INT.CL.

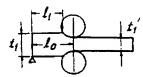
B21B 1/22

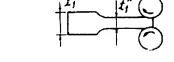
TITLE

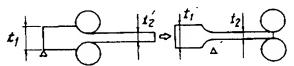
: ROLLING METHOD FOR PROVIDING

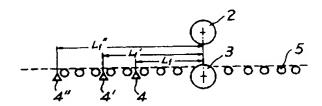
STEP DIFFERENCE TO THICK PLATE











ABSTRACT :

PURPOSE: To roll a rolling material into a plate having a large step difference without causing turbulence in its flatness by controlling the advancing and returning rollings of the material, in rolling a rolling material by leaving a part of the material by a prescribed length and rolling the other part into a thinner one through several passes of reversing rollings.

CONSTITUTION: A steel plate 1 rolled into the sheet thickness t<sub>1</sub> is rolled into the sheet thickness t<sub>1</sub>' by upper and lower work rolls 2, 3 having a roll gap S<sub>1</sub> between them, and when the top of plate 1 is detected by a steel plate detector 4, the rotation of mill is stopped to leave a thick-plate part having thickness t<sub>1</sub> by a length l<sub>1</sub>. Successively a return rolling is performed by reversing the mill to obtain a thin-plate part having sheet thickness t<sub>1</sub>". Further, the 2nd pass rolling is performed to obtain a thin plate-thickness t<sub>2</sub>' part by regulating the roll gap to  $S_2(S_1>S_2)$ , and the mill is reversed when the detector 4 detects the top of plate 1 to obtain a thin plate-thickness t2 part. In this way, a plate with different thicknesses is obtained, which consists of a part having a prescribed length I1 and a sheet thickness t<sub>1</sub> and a remaining part having a sheet thickness t<sub>2</sub>.

COPYRIGHT: (C)1985,JPO&Japio